

Date: Monday, 11/21/2005 7:39:24 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 24864  
 Estimate Number : 10792  
 P.O. Number : N/A  
 This Issue : 11/21/2005 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LANDING GEAR  
 Previous Run : N/A  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est Rev:A 04.09.28 New Issue KJ/JLM

Drawing Name : FLOAT WEB  
 Part Number : D3289041  
 Drawing Number : D3289 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : N/A  
 Due Date : 12/20/2005 Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number  
 1 D2600-5-108

Description Batch  
 Web B24410

DP 06-3-1

2.0 D32833 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number  
 2 D3283-3

Description Batch  
 Doubler B24885-B25879

DP 06-3-1

3.0 MS20470AD47 Rivet, Universal Head



Comment: Qty.: 85.0000 Each(s)/Unit Total: 850.0000 Each(s)

Pick:

Qty Part Number  
 85 MS20470AD4-7

Description Batch  
 Rivet H15924/M19185

DP 06-3-1

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5-108 to 96.7" as per Dwg D3289

IT 06-03-10

2-Transfer drill web from D3283-3 doublers

IT 06-03-10

3-Drill web using DT8748 as per Dwg D3289

IT 06-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	(9)						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 7:39:24 PM  
User: Linda Lacelle

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 24864

Part Number: D3289041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Using uni-bit, open holes as per Dwg D3289

RT 06-03-10 (10)

5-Deburr holes and ends

RT 06-03-13 (10)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

RT 06-03-22 (10)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-03-28

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Rivet doublers as per Dwg D3289

A/R LPS-3 Batch: M17395

RT 06-03-30 (10)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-30

P70

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LA cell

RT 06-03-30 (10)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-03-30 (10)

Job Completion



06-03-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-30	7.0	3 holes oversized while removing damaged rivets in the web and doublers, on 1 web only.	AB 06-03-30	Scrap, And use for test tube bending		06-03-30	AB 06-03-30	06-03-30

NOTE: Date & initial all entries

□□□□□□□□

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	: 0024864	Department Code:	
Project Name	: D3289-041	Burden Flags	: NNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3289-041	Invoice Number	:
Description	: Float Web (206A/B)	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-20-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

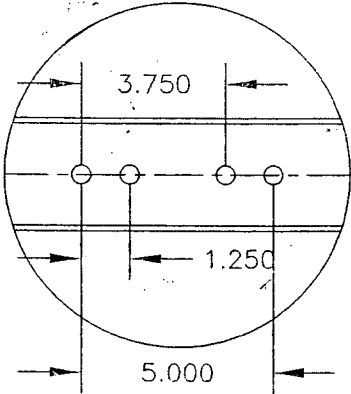
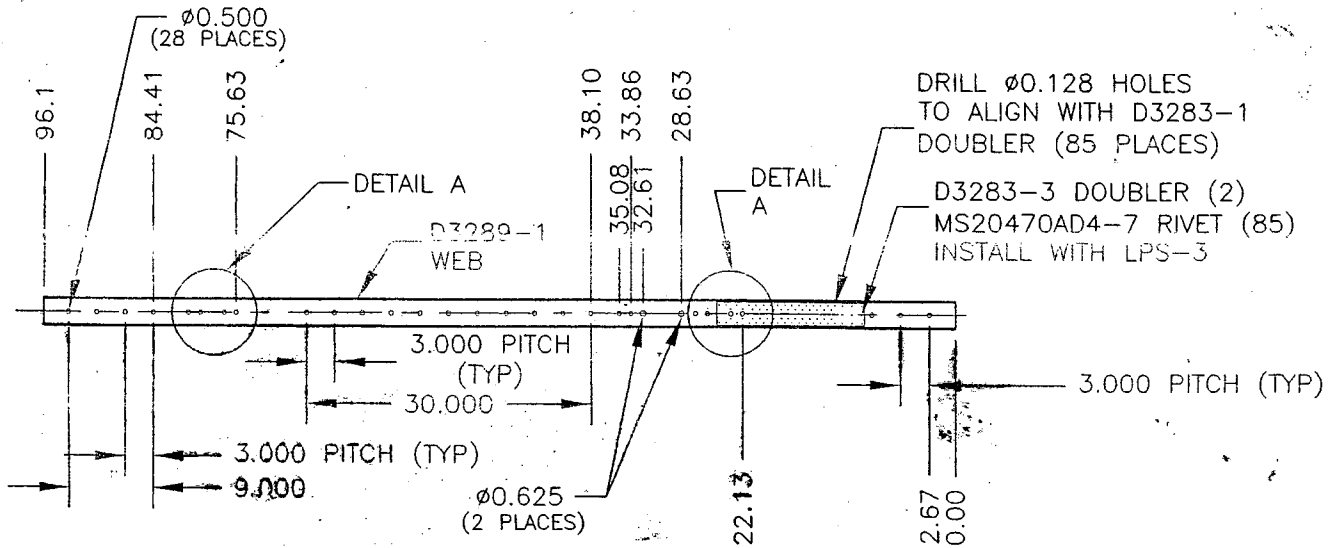
	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

CONTROLLED COPY

DART

RELEASED  
050706

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE	USA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLO	
DATE	05.03.16			DRAWING NO.	D3289
				TITLE	FLOAT WEB, 206A/B
	A	04.05.18		NEW, ISSUE	
	B	05.03.16		ADD HOLES FOR OEM COMPATIBILITY	



**DETAIL A**  
SCALE 1:5  
RIVET HOLES NOT SHOWN

- 1) MAKE FROM D2600-5-108 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART-QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) HOLE LOCATIONS ARE SPACED 3.000 BETWEEN D3283-3 DOUBLERS AND D3289-1 WEB. INSTALL RIVETS COATED IN LPS LABORATORIES LPS-3

